



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			






NOTE: Date & initial all entries



**Work Order ID 53437**




November 04, 2009 10:41:27 AM



Page 2

Item ID: D3953-15 Accept  Setup Start   
Revision ID: A Stop   
Item Name: Gas Spring Bracket  
Start Date: 11/5/2009 Start Qty: 10.00  Cust Item ID:  
Required Date: 11/10/2009 Req'd Qty: 10.00  Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start   
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00				count (22)	4		
130  Small Fab Small Fab	Memo 1- CHAMFER HOLE AS PER DWG 2- DEBURR IF NECESSARY	0.00  0.00							0509/11/06 (22)
140  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00				count (22)	4		

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**Work Order ID 53437**

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Item ID: D3953-15

Accept



Setup Start



Revision ID: A

Stop



Item Name: Gas Spring Bracket

Start Date: 11/5/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 11/10/2009 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

Identify as per dwg & Stock Location: 1390

0.00



Packaging

Memo

0.00

Packaging

9/11/9sf(22x)

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/09 HDBl 09-11-9  
(22)

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**NOTE:** Date & initial all entries

# Picklist Print

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Page 1

Work Order ID: 53437



Parent Item: D3953-15



Parent Item Name: Gas Spring Bracket


Start Date: 11/5/2009

Required Date: 11/10/2009

Comments: IPP RevA: New issue 09.10.13 DD verified by:EC

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S11GA  304/316 0.125 Sheet		Purchased	No			100	sf	135.2057	0.2074	1.		



189-11-4

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

135.2056979

111018

7.20569789

112663

128

111018

# Dart Aerospace Ltd

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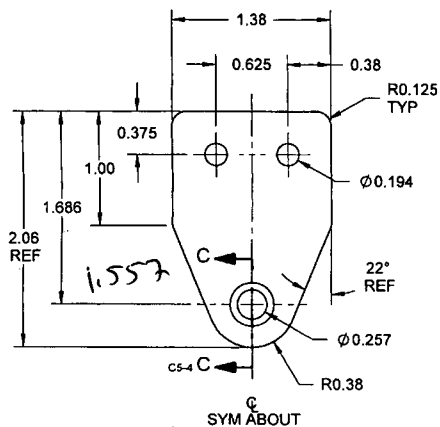
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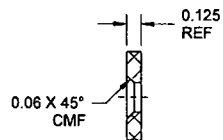
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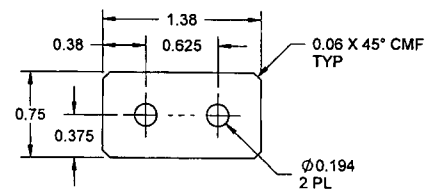
**NOTE:** Date & initial all entries



**D3953-15 GAS SPRING BRACKET**  
(SPLIT LID)



**SECTION C-C** C7-4



**D3953-17 GAS SPRING SPACER**  
(SPLIT LID)

**NOTES:**

1) MATERIAL -15: MATERIAL: AISI 304 STAINLESS STEEL SHEET, 0.125 THICK  
REF DART SPEC M304S

-17: AISI 304 STAINLESS STEEL BAR  
REF DART SPEC M304B

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3953-X" USING FINE POINT PERMANENT INK MARKER

7) WEIGHT -15: 0.08 lbs

-17: 0.10 lbs

**RELEASED**  
2009-10-08  
*wp*

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3953	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	GAS SPRING LID COMPONENTS	NTS
DATE	09.07.27	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

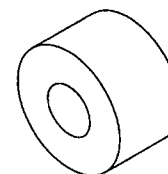
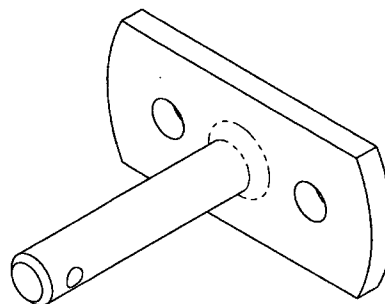
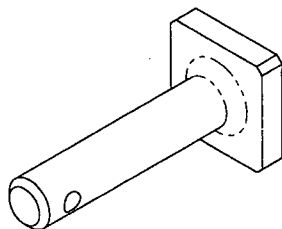
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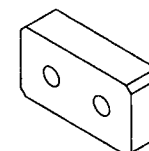
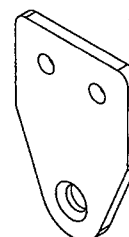
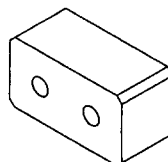
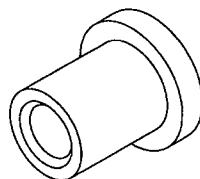
**D3953-1 GAS SPRING BRACKET**  
(FULL LID)

**D3953-3 GAS SPRING STUD, LID**

**D3953-5 GAS SPRING STUD, BASE**

**D3953-7 GAS SPRING SPACER**

**D3953-9 GAS SPRING WASHER**



#52437

**D3953-11 GAS SPRING SPACER**

**D3953-13 GAS SPRING SPACER**  
(FULL LID)

**D3953-15 GAS SPRING BRACKET**  
(SPLIT LID)

**D3953-17 GAS SPRING SPACER**  
(SPLIT LID)

**RELEASED**  
2009-10-08

A		NEW ISSUE		AJS		09.07.27	
REV.		DESCRIPTION				BY DATE	
DESIGN		AJS		DART AEROSPACE LTD			
DRAWN		AJS		HAWKESBURY, ONTARIO, CANADA			
CHECKED		<del>A</del>		DRAWING NO.		REV. A	
MFG. APPR.		<del>B</del>		D3953		SHEET 1 OF 4	
APPROVED		<del>NO</del>		TITLE		SCALE	
DE APPR.		<del>TH</del>		GAS SPRING LID COMPONENTS		NTS	
DATE		09.07.27		COPYRIGHT © 2009 BY DART AEROSPACE LTD			
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